

Work Order ID 102138

May-27-13 12:39:53 PM

Item ID: D3255-2

Revision ID:

Item Name: Panel

Start Date: 5/27/13 Start Qty: 4.00

Accept

102138

Page 1

Required Date: 5/31/13 Req'd Qty: 4.00

4***N900040100***

Setup

Start

NS1

Stop

NS2

Reference:

Approvals: Process Plan: MLJDate: 5-05-27 Tooling:

Cust Item ID:

QC:

Date:

SPC (Y/N):

Customer:

Run

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

0.00

4

0

JmB-07-30

100

100

FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3255 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

Memo

0.00

QC

Quality Control

4

0

JmB-07-30

120

QC8- Inspect parts - second check

0.00

120

Memo

0.00

QC

Quality Control

(1) B-07-30

DAS
09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<p>Landing Gear</p> <p><input type="checkbox"/> Bending</p> <p><input type="checkbox"/> Centre Not Concentric to O/S</p> <p><input type="checkbox"/> Cracks</p> <p><input type="checkbox"/> Crushed/Crimped</p> <p><input type="checkbox"/> Cuffs</p> <p><input type="checkbox"/> Heat Treat</p> <p><input type="checkbox"/> Inspection Strip in Tube</p> <p><input type="checkbox"/> Ripples in Bend</p> <p><input type="checkbox"/> Torque Waves in Extrusion</p> <p><input type="checkbox"/> Turning Sequence</p> <p><input type="checkbox"/> Wave/Twist in Tube</p>				<p>General</p> <p><input type="checkbox"/> Bend</p> <p><input type="checkbox"/> BOM/Route</p> <p><input type="checkbox"/> Broken/Damaged</p> <p><input type="checkbox"/> Burrs</p> <p><input type="checkbox"/> Contamination</p> <p><input type="checkbox"/> Countersink</p> <p><input type="checkbox"/> Cut Too Short</p> <p><input type="checkbox"/> Drill Holes</p> <p><input type="checkbox"/> Drawing</p> <p><input type="checkbox"/> Finish</p> <p><input type="checkbox"/> Folio</p>		<p><input type="checkbox"/> Grain</p> <p><input type="checkbox"/> Hardware</p> <p><input type="checkbox"/> Inspection Incomplete</p> <p><input type="checkbox"/> Instructions Incomplete/Unclear</p> <p><input type="checkbox"/> Maintenance</p> <p><input type="checkbox"/> Mislabeled</p> <p><input type="checkbox"/> Misread</p> <p><input type="checkbox"/> Offset</p> <p><input type="checkbox"/> Out of Calibration</p> <p><input type="checkbox"/> Out of Sequence</p> <p><input type="checkbox"/> Outside Dimensions</p>					
						<p><input type="checkbox"/> Ovalized</p> <p><input type="checkbox"/> Over/Under tolerance</p> <p><input type="checkbox"/> Part Incorrect</p> <p><input type="checkbox"/> Part Lost/Missing</p> <p><input type="checkbox"/> Part Moved</p> <p><input type="checkbox"/> Positioned Wrong</p> <p><input type="checkbox"/> Power Loss/Surge</p> <p><input type="checkbox"/> Other</p>					

Work Order ID 102138***102138***

Page 2

May-27-13 12:39:53 PM

Item ID: D3255-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Panel

Stop

NS2

Start Date: 5/27/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

4

0

FF13-08-08

Brake NC

Memo

0.00

140

140

QC

QCS- Inspect part completeness to step on W/O

0.00

DAS
27
1388

4

Quality Control

Memo

0.00

150

150

Packaging

Identify as per dwg & Stock Location: U/A

0.00

Packaging

Memo

0.00

4

13-08-08

JAC

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>							
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>							
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>							
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>								
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Work Order ID 102138

May-27-13 12:39:53 PM

Item ID: D3255-2

Revision ID:

Item Name: Panel

Start Date: 5/27/13 Start Qty: 4.00

Accept

4

Required Date: 5/31/13 Req'd Qty: 4.00

4

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Sequence ID/
Work Center ID

160

160

QC

Quality Control

102138

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Operation Description Set Up/
Run Hours

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

May 23-08-12

QC 13-8-8

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>							
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector			
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
												<input type="checkbox"/> Other			

Picklist Print

May-27-13 12:39:53 PM

Page 1

Work Order ID: 102138

Parent Item: D3255-2

Parent Item Name: Panel

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	181.9800	1.484	62484212 6.5			JM3-07-30
---------------------------------	--	-----------	----	--	--	-----	----	----------	-------	-----------------	--	--	-----------

Location	Loc Qty	Loc Code
MAT020	181.98	
118271	10.76	
120866	55.47	
121889	115.75	121889

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/>				Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/>				Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/>	
												<input type="checkbox"/>			

DART AEROSPACE LTD	Work Order:	102138
Description: Access Panel Assembly	Part Number:	D3255-2
Inspection Dwg: D3255	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAY

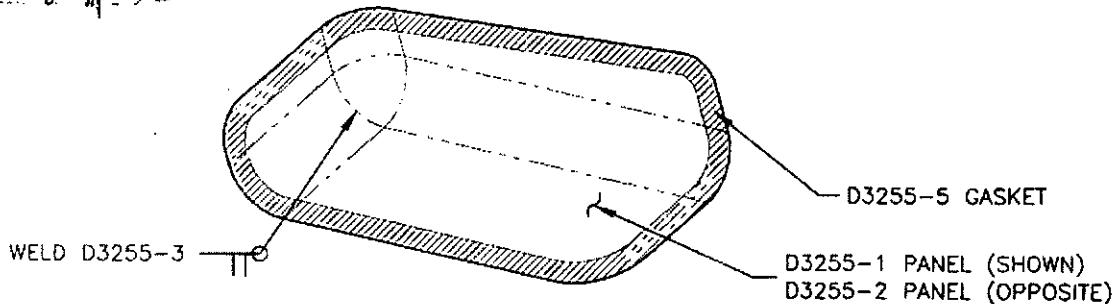
Measured by: Jm	Audited by: 99 89	Prototype Approval: N/A
Date: 13.07.30	Date: 13.07.30	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.06	New Issue	KJ/DD	

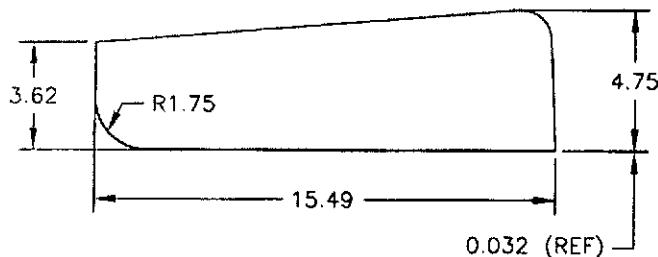
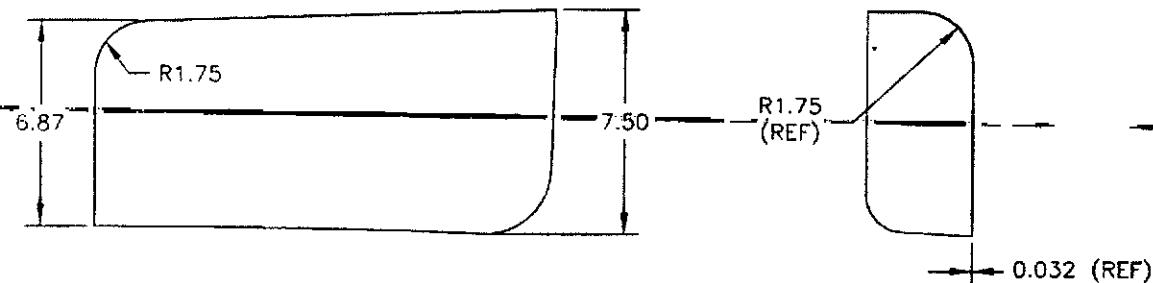


DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3255		SHEET 1 OF 4
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:6	
A	04.01.27	NEW ISSUE		
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098		

RELEASED
05.01.08

**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**

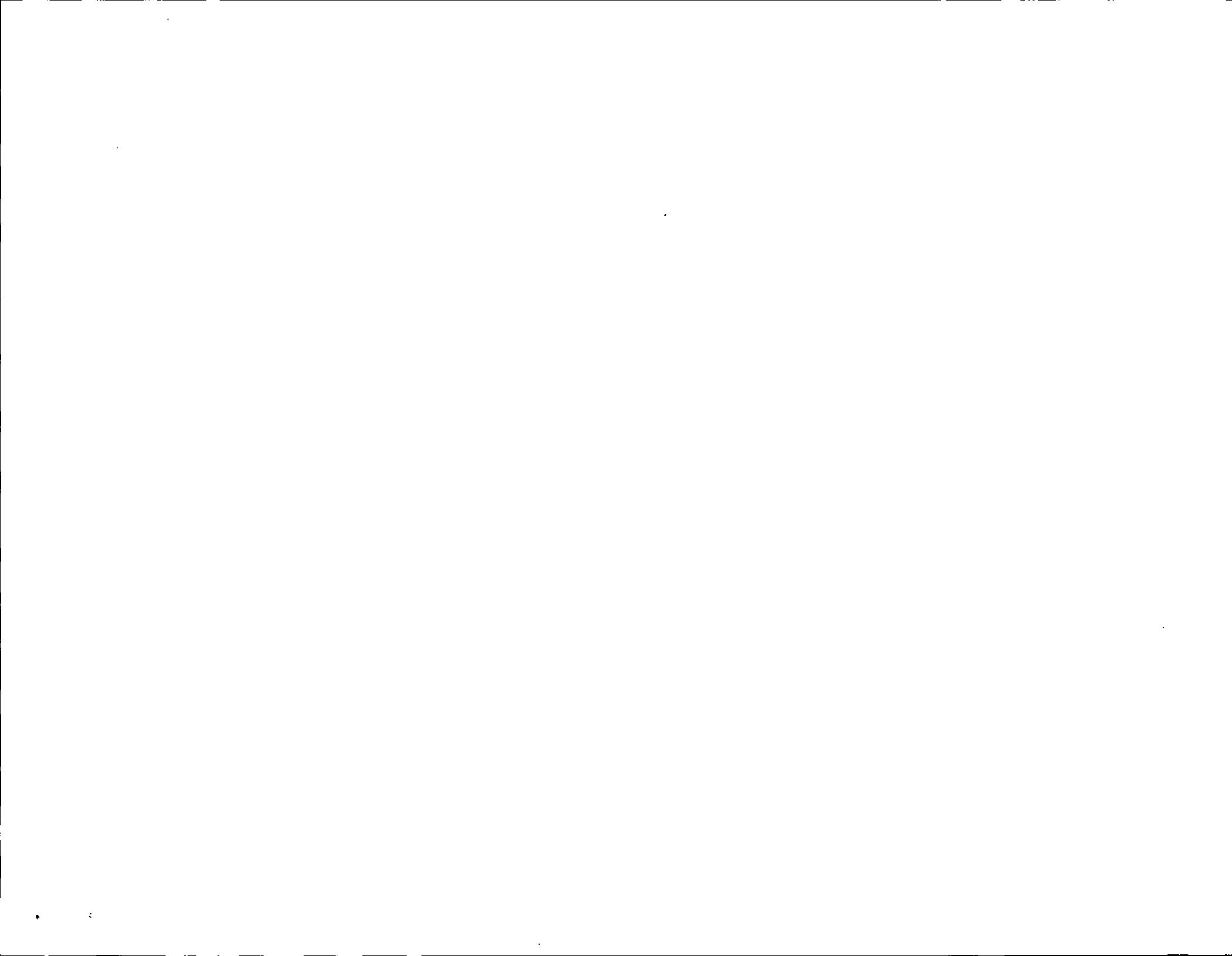


102138 5-2
13-05-2008
D3255-1

**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

D3255-041/-042 NOTES:

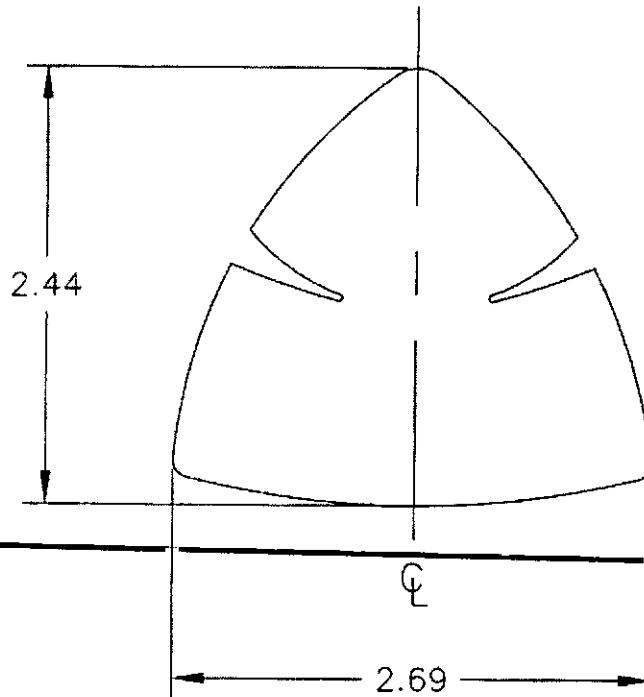
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DART

DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED IP	APPROVED H	DRAWING NO. D3255	REV. B	SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1	

RELEASED
11 05.01.08 H



D3255-3 CAP
FORM TO FIT D3155-1/-2

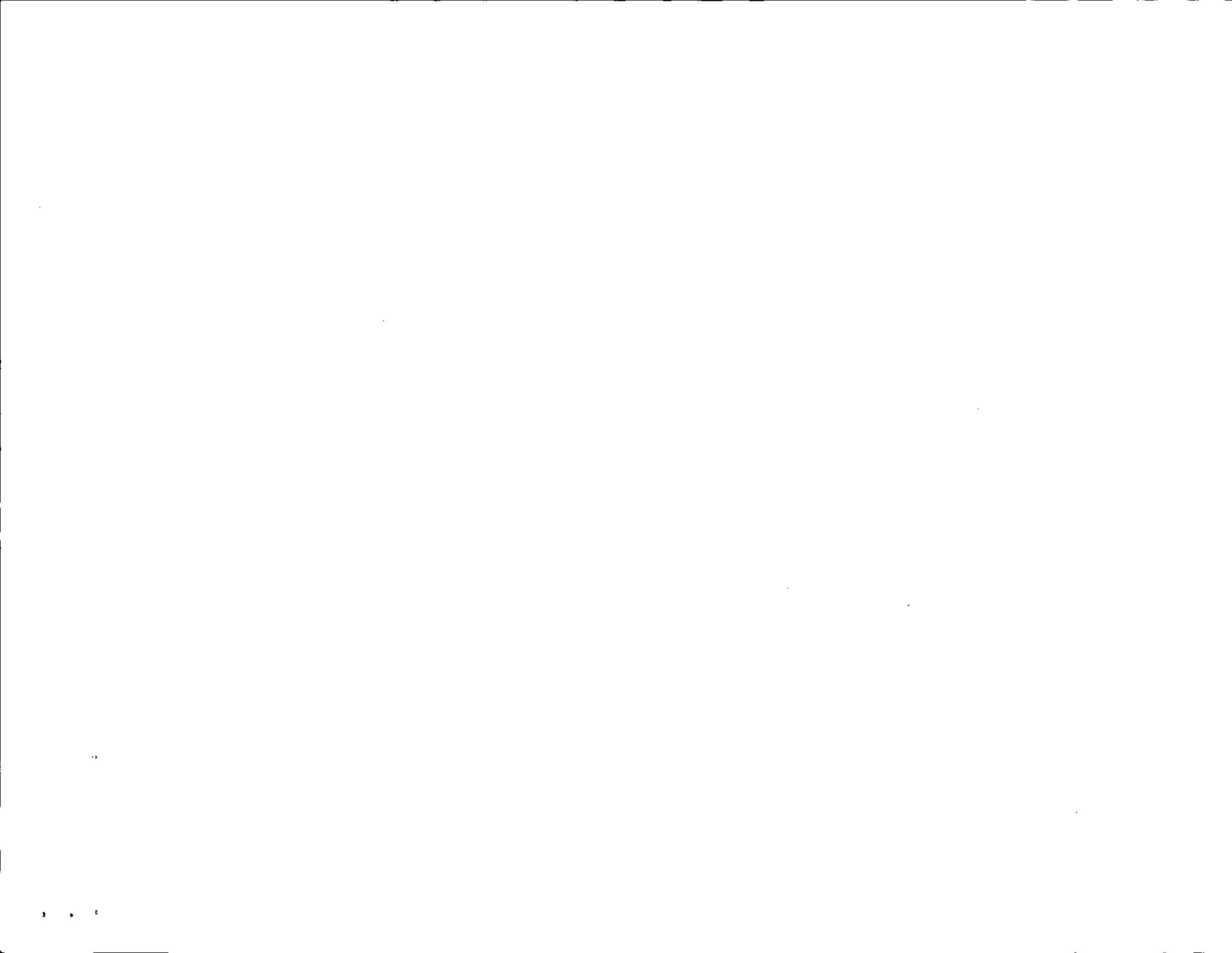
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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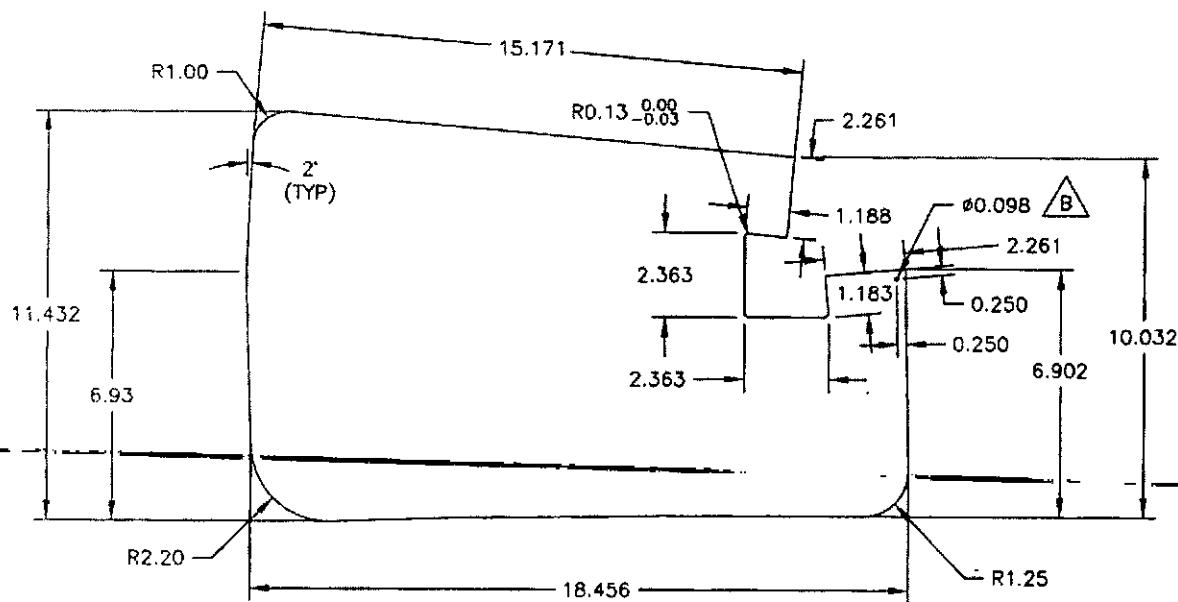
8/1/201



DART

DESIGN J.F	DRAWN BY J.F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18

D3255-1/-2 FLAT PATTERND3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

10/2013

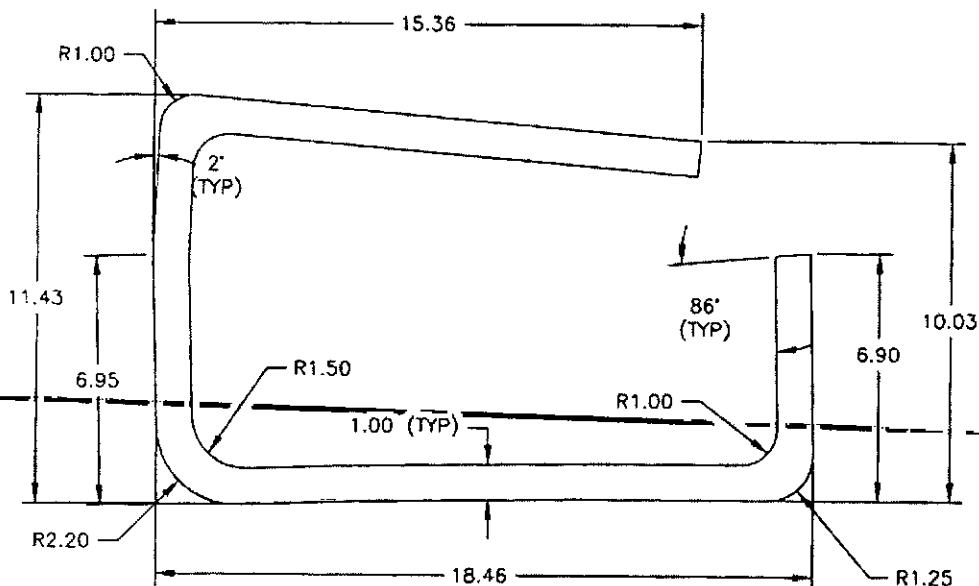
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DART

DESIGN 17	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED IP	APPROVED H	DRAWING NO. D3255	REV. B	SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05/01/08 H

**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

102138

